

Work Order ID 54312

December 7, 2009 3:09:04 PM



Page 1

Item ID: D3474-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Control Arm

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: RP

Date: 08/12/07

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3474

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D

☐ Dwg Rev: A

☐ Prog Rev: A

HB 9-12-8

(33)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-12-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 8/10/02/02

counter
(x33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54312

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Page 2

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Setup Start



Revision ID:

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Item Name: Control Arm

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab Memo Deburr if necessary.	0.00 0.00	⇒ M-L 10/02/01			(33X)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 8/10/02/02			(33)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>61</u> Memo	0.00 0.00	⇒ 10/2/3			(33)			

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Work Order ID 54312

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Page 3

Item ID: D3474-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Control Arm

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03

mf

10-2-3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 7, 2009 3:09:08 PM

Page 1

Work Order ID: 54312



Parent Item: D3474-3



Parent Item Name: Control Arm


Start Date: 07/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S13GA 		Purchased	No			100	sf	32.0000	0.1263	1.0		

304/316 .090" Sheet

LB 9-12-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

103033

32

32

103033

33

W/O:		WORK ORDER CHANGES					
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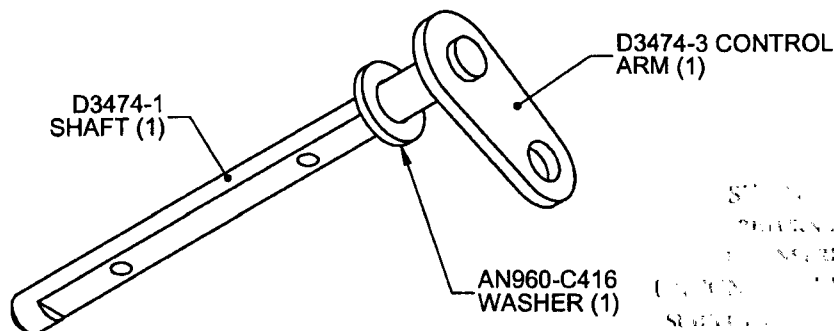
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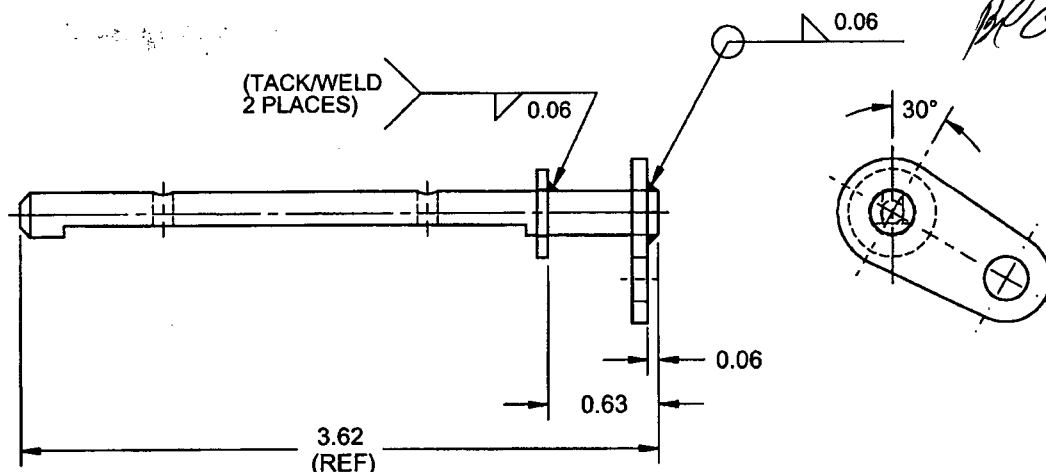
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1
A	06.01.23	NEW ISSUE	

[Handwritten] 06.04.03



STANDARD
RETURNED
TO SENDER
UNLESS NOTED
OTHERWISE
VENDOR'S
NO. 54312

[Handwritten] 09-12-7



D3474-041 INLET VALVE SHAFT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

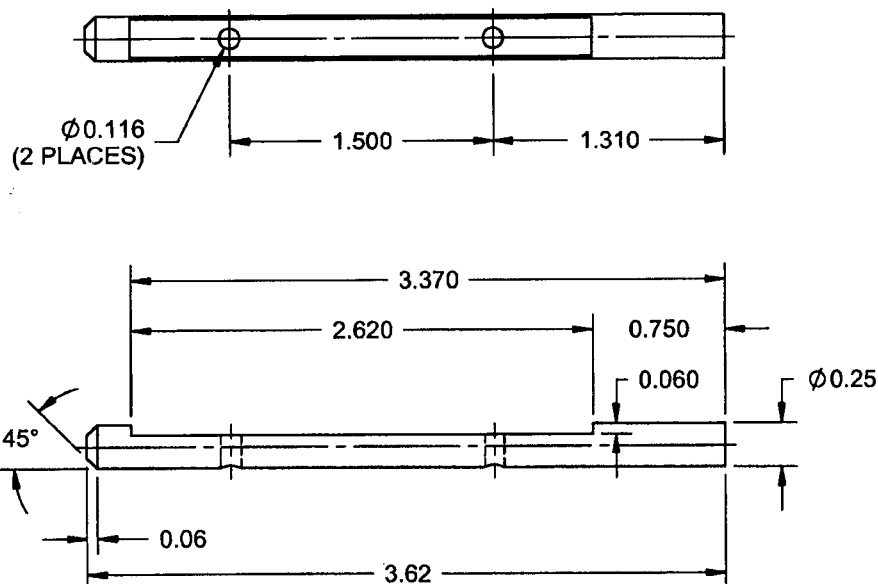
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 2 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

W/O 54312

[Signature] 06.04.03



D3474-1 SHAFT

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

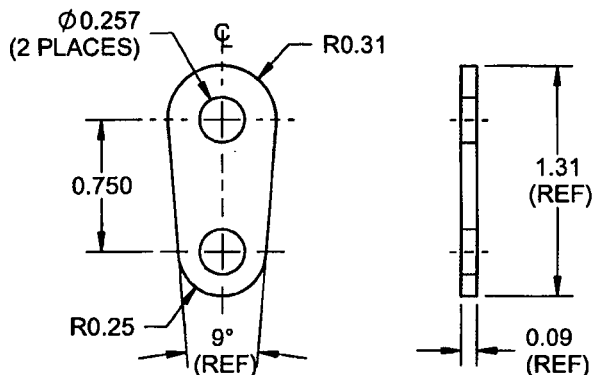
W/O 54312

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3474	REV. A SHEET 3 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

H 06.04.03

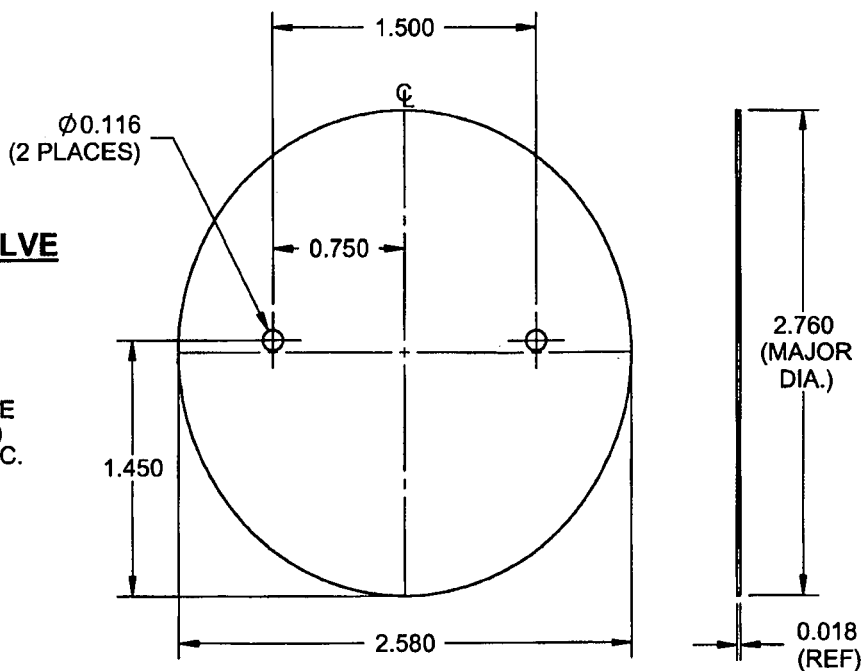
D3474-3 CONTROL ARM FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3474-5 BUTTERFLY VALVE FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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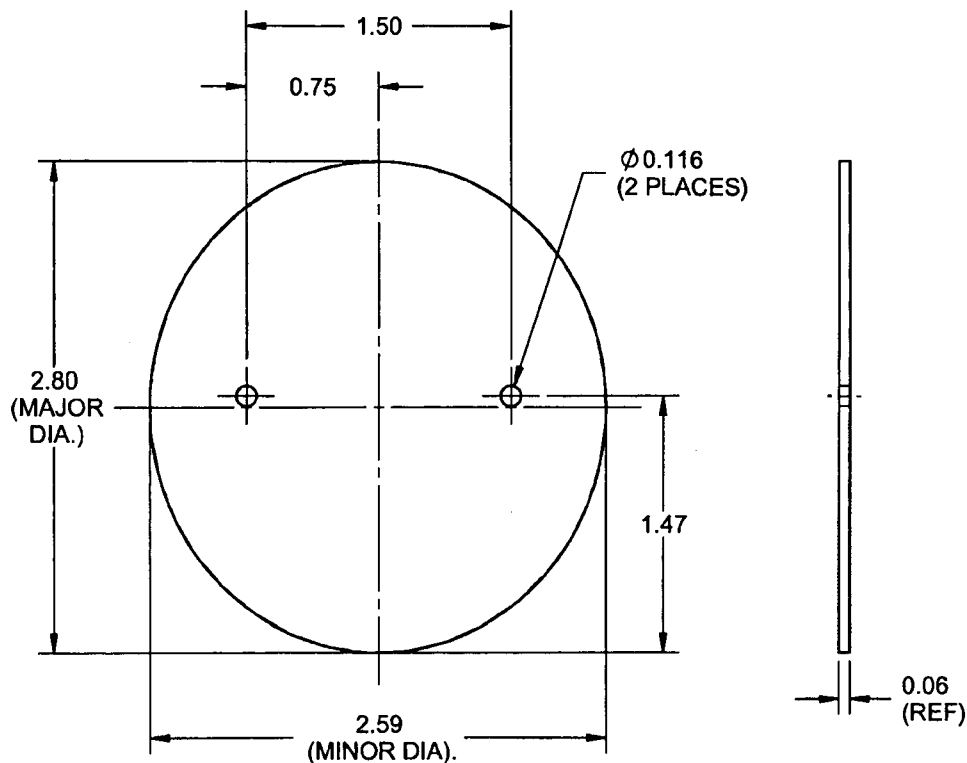
NOTE: Date & initial all entries



W/O 54312

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

[Signature] 06.04.03



D3474-7 BUTTERFLY VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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